

Work Order ID 86150

86150

Page 1

Item ID: D2066

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2066

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

cut at 28.88

0.00

1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube
(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

SAD

12-11-07

4-Bend per Dwg D2066

5-Drill using DT9034

④

FF
12-11-12

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

121112

4

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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June-21-12 8:40:43 AM

Item ID: D2066

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

PPP 98636.

4K

SP
12-11-13.

12/11/14

W 12-11-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-21-12 8:40:47 AM

Page 1

Work Order ID: 86150

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP D 02.03.18 Added pick list NG
IPP E 07.10.03 removed p/c EC verified by: DD
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	16			
<div><div>*AN960.ID10*</div><div>Washer</div></div> <div>m123248**16 SAA12-11-06</div>													
D2052		Manufactured	No			100	Each	16.0000	2	8			
<div><div>*D2052*</div><div>Mounting Bracket</div></div> <div>**SAA12-11-06</div>													
<div><div>Location</div><div>Loc Qty</div><div>Loc Code</div></div> <div><div>GA</div><div>16</div><div></div></div> <div><div>73052</div><div>3</div><div>288361</div></div> <div><div>83341</div><div>13</div><div></div></div>													
D2054		Manufactured	No			100	Each	14.0000	2	8			
<div><div>*D2054*</div><div>Bushing</div></div> <div>**SAA12-11-06</div>													
<div><div>Location</div><div>Loc Qty</div><div>Loc Code</div></div> <div><div>GA</div><div>14</div><div>B79836</div></div> <div><div>79836</div><div>14</div><div>B87818</div></div>													
D2055		Manufactured	No			100	Each	11.0000	1	4			
<div><div>*D2055*</div><div>Clamp</div></div> <div>**SAA12-11-06</div>													
<div><div>Location</div><div>Loc Qty</div><div>Loc Code</div></div> <div><div>GA</div><div>11</div><div></div></div> <div><div>77110</div><div>11</div><div></div></div>													
<div><div>(4)</div></div>													

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Picklist Print

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Page 2

Work Order ID: 86150

Parent Item: D2066

Parent Item Name: Arm

86150

D2066

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2056

Manufactured No

100

Each

3.0000

1

4

D2056

Bell Crank

**

S SAD 12-11-06

Location

Loc Qty

Loc Code

GA

3

71102

2

71889

1

MS21042L3

Purchased No

100

Each

3,654.000

85943

(4)

8

MS21042L3

Nut

**

SAD 12-11-06

Location

Loc Qty

Loc Code

ST300

1654

117885

32

119017

816

119075

138

121444

668

ST317

2000

122141

2000

MS27039-1-18

Purchased No

100

Each

41.0000

1122452

2

8

MS27039-1-18

Screw

**

SAD 12-11-06

Location

Loc Qty

Loc Code

ST291

41

115589

1

120308

15

121556

25

1123522

(8)

June-21-12 8:40:48 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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June-21-12 8:40:48 AM

Page 3

Work Order ID: 86150

Parent Item: D2066

Parent Item Name: Arm

86150

D2066

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

M304TR0.500W.049

Purchased

No

120

f

186.4011

2.386

10.04632

M304TR0 500W 049

304 RD Tube .500 x .049W

**

SAD

12-11-07

Location

Loc Qty

Loc Code

MAT017

186.40111

111814

2.23

115010

109.254058

117598

1.47

119087

7.359

120633

66.088052

10.0469

June-21-12 8:40:48 AM

Shop Packet Print

Page 3

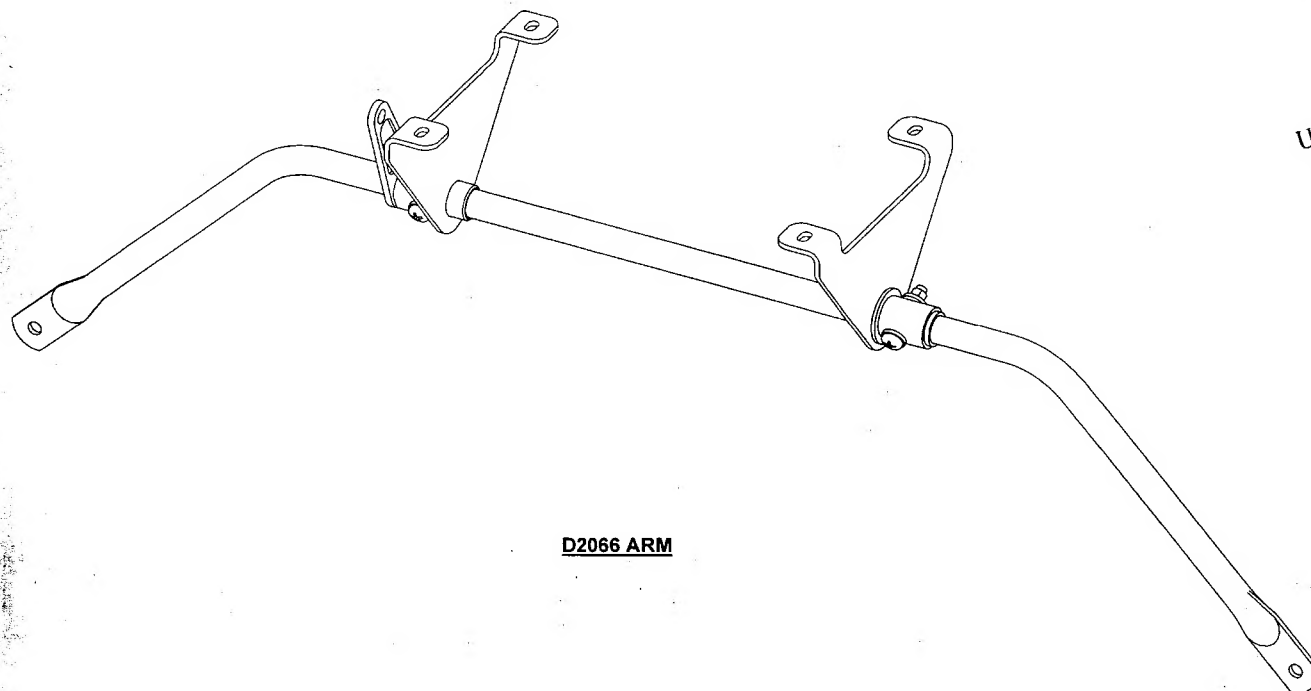
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2066 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86150-1165
12/06/21

RELEASED
08-07-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS: ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	FL		
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	SE	D2066	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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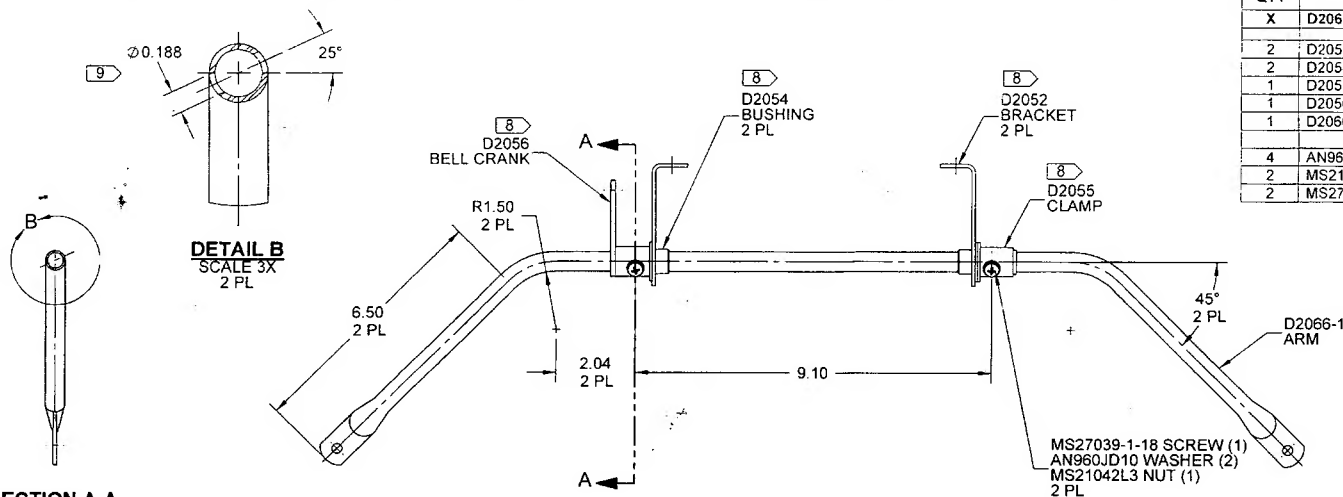
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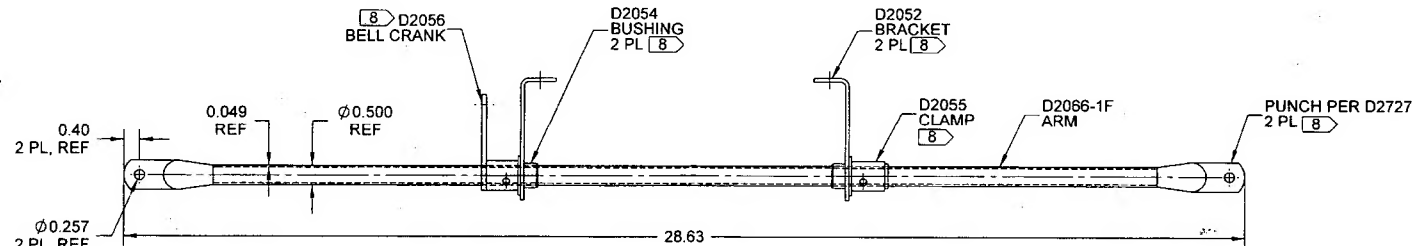
3 7 6 5 4 3 2 1



QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW

86150

D2066-1 ARM BENDING DETAIL (MAKE FROM D2066-1F)



D2066-1F ARM CUT LENGTH DETAIL

- NOTES:**
- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
 - 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
 - 9) DRILL $\phi 0.188$ AFTER BENDING

RELEASED 08-07-23

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AL		
CHECKED	JS	DRAWING NO. D2066	REV. C
MFG. APPR.	JS	SHEET 2 OF 2	
APPROVED	JS	TITLE ARM	SCALE
DE APPR.	JS	NTS	
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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